

Work Order ID 51968

September 10, 2009 3:03:48 PM



Page 1

Item ID: D3927-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Guard

Start Date: 9/14/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *B*

Date: *09-9-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3927

A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut MAT 19.250" Long

DIP 09/09/21

3

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

HAAS

1-Mill as per folio FA & dwg D,

FOLIO REV: *A*

DWG REV: *A*

SL 09/09/21

2-Deburr as required

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Page 2

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

JK 09/09/21

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

JK 09/09/21

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 139

0.00

PC 9/9/22 (3)

Packaging

Memo

0.00

Packaging

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Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/09

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

09/09/22 
MF 09-09-22

Picklist Print

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Work Order ID: 51968

Parent Item: D3927-3RevA

Parent Item Name: Guard

Start Date: 9/14/09

Required Date: 9/24/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRLINB2.000X02.0 00		Purchased	No			100	f	6.3200	7.0737			



DELRLIN BAR

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

6.32

111828

6.32

5,3053 DTP 09/09/21

DART AEROSPACE LTD		Work Order: 51968
Description: guard		Part Number: N3927-3
Inspection Dwg: N3927	Rev: A	Page 1 of 1

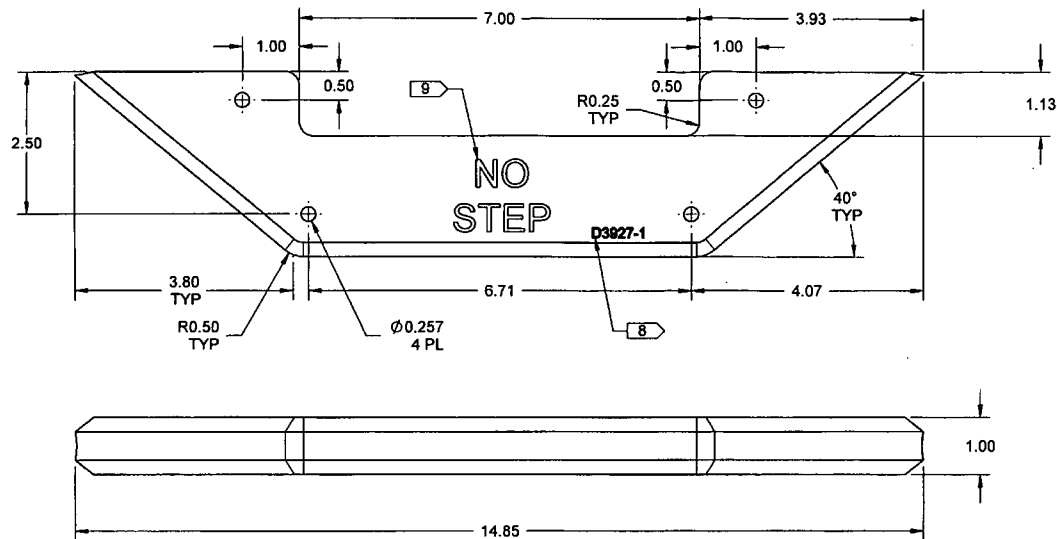
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.251	+0.006 -0.001	258	✓			
1.52	± .030	1.518	✓			
1.04	± .030	1.041	✓			
1.10	± .030	1.10	✓			
19.00	± .030	18.970	✓			
21°	± .5°	21°	✓			
.50	± .030	.499	✓			
15.00	± .030	15.00	✓			
.25X45°	± .030 ± .5°	.250X45°	✓			
5.45	± .030	.448	✓			
18.50	± .030	18.470	✓			
13.15	± .030	13.150	✓			
1.50	± .030	1.498	✓			
.88	± .030	.893	✓			
.80	± .030	.799	✓			
.60	± .030	.598	✓			
.50	± .030	.500	✓			
.98	± .030	.979	✓			
1.23	± .030	1.225	✓			
1.52	± .030	1.518	✓			

Measured by: SL	Audited by: SL	Prototype Approval:	N/A
Date: 09/09/21	Date: 09/09/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3927-1 GUARD

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.0 THICK
PER DART SPEC M-DELRIN-S1.0
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.90 lbs
- 8) ENGRAVE "D3927-1" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 AT LOCATION INDICATED
- 9) ENGRAVE "NO STEP" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 AT LOCATION INDICATED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51968

A	NEW ISSUE	BY	09.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.31		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3927	REV. A SHEET 1 OF 2
TITLE GUARD	SCALE NTS
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09/03/11

